

TRIAL FIT

Order ID 88687

88687

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30-12 2:33:12 PM

Item ID: D3650-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Panel

Start Date: 7/30/12

Start Qty: 1.00

1
1 2

Cust Item ID:

Required Date: 7/31/12

Req'd Qty: 1.00 2

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3650

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3650 Dwg Rev: 1

Prog Rev: 2-

Deburr if necessary

304 .018

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Scrap 12/07/31
12/08/22
12/07/31

2 0 Jm 12-7-30
2 0
2 0
2 0

DA
29
88
DA
29
88

Work Order ID 88687

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Item ID: D3650-1

Revision ID:

Item Name: Aft Panel

Start Date: 7/30/12

Start Qty: 1.00

1

Required Date: 7/31/12

Req'd Qty: 1.00

1

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3650

140

0.00

140

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

150

0.00

150

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D3650

Picklist Print

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Page 1

Work Order ID: 88687

Parent Item: D3650-1

Parent Item Name: Aft Panel

Start Date: 7/30/12

Required Date: 7/31/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
 IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
 IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA 304/316 0.018 SHEET		Purchased	No			150	sf	74.2500	1.583	1.6663158			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT020		74.25							
				117798		74.25							
MS20427M3-3 Rivet		Purchased	No			150	Each	1,077.0000	18	18			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		1074							
				121114		1074							
				ST318		3							
				120930		3							
MS21060-3K Nut Plate		Purchased	No			150	Each	111.0000	6	6			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST302		111							
				116857		17							
				117423		13							
				117977		50							
				118267		31							
MS21062-3K Nut Plate		Purchased	No			100	Each	102.0000	3	3			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				317		50							
				122452		50							
				ST302		52							
				109590		4							
				117343		48							

Jm 12-7-30

DART AEROSPACE LTD		Work Order: 88687
Description: aft panel		Part Number: D3650-1
Inspection Dwg: D3650 Rev:		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.45	± 0.030	15.45	✓		MT	
13.76	± 0.030	13.78	✓		MT	
13.06	± 0.030	13.08	✓		MT	
12.09	± 0.030	12.09	✓		MT	
0.40 Typ	± 0.030	0.40	✓		✓	
0.78 Typ	± 0.030	0.791	✓		✓	
0.213	± 0.005 ± 0.001	0.213	✓		✓	
1.32	± 0.030				✓	Revs DIM
0.78	± 0.030	0.78	✓		✓	
3.32	± 0.030	3.326	✓		MT	
3.35	± 0.030	3.36	✓		MT	
7.75	± 0.030	7.75	✓		MT	
7.81	± 0.030	7.87	✓		MT	
1.943	± 0.010	1.952	✓		MT	
5.884	± 0.010	5.889	✓		MT	
8.248	± 0.010	8.248	✓		MT	
8.74	± 0.030	8.75	✓		MT	
8.87	± 0.030	8.874	✓		MT	
9.196	± 0.010	9.199	✓		MT	
9.49	± 0.030	9.500	✓		MT	
10.49	± 0.030	10.500	✓		MT	
12.90	± 0.030	12.90	✓		MT	

Measured by: Smb
Date: 12-7-31

Audited by: SPR 29
Date: 12/07/31

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

DART AEROSPACE LTD		Work Order: 88687
Description: aft panel		Part Number: 13650-1
Inspection Dwg: 0365	Rev:	Page: 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.88	± 0.030	2.88	✓		MT	
3.91	± 0.030	3.91	✓		MT	
PO 13 TYP						
0.16	± 0.030	0.166	✓		✓	
13.80	± 0.030	13.81	✓		MT	
15.53	± 0.030	15.535	✓		MT	
0.08	± 0.030	0.08	✓		✓	
1.06	± 0.030	1.064	✓		✓	
0.97	± 0.030	0.974	✓		✓	
0.35 TYP	± 0.030	0.35	✓		✓	
0.221	± 0.010	0.220	✓		MT	
11.99	± 0.030	11.995	✓		MT	
10.65	± 0.030	10.655	✓		MT	
9.55	± 0.030	9.55	✓		MT	
7.19	± 0.030	7.195	✓		MT	
3.22	± 0.030	3.23	✓		MT	
4.99	± 0.030	4.99	✓		MT	
2.28	± 0.030	2.29	✓		MT	
0.14	± 0.030	0.144	✓		✓	
0.84	± 0.030	0.845	✓		✓	
3.30 Ref	0.030					
1.77	± 0.030	1.772	✓		✓	
1.04	± 0.030	1.041	✓		✓	

Measured by: Smb
Date: 12-7-31

Audited by: [Signature]
Date: 12/01/31

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

